



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7702

Job Sheet 169387



Part No: 647.7702

Job Qty: 10 ea

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/8/17

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/12/18

Description:

Type: Stock

Note: DWG REV A2 IPP REV:A 12.11.01 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	1/11/18	1/11/18	0.00	0.00	Start Up Large Fab-1		EL
110	Packaging	10 pcs	1/11/18	1/11/18	0.00	0.00	Packaging1-1		EL
120	Large Fab	10 pcs	1/11/18	1/11/18	0.00	4.12	Large Fab 4		EL
130	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC9		PD 13-01-10
140	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC5		PD 13-01-10
150	Outsource	10 pcs	1/11/18	1/11/18	0.00	0.00	Outsource3		AT 18/02/05
160	Packaging	10 pcs	1/11/18	1/11/18	0.00	0.00	Packaging2		ADAE 10/05
170	QC	10 pcs	1/11/18	1/11/18	0.00	0.00	QC5		38
180	SprayPaint	10 pcs	1/12/18	1/12/18	0.00	0.77	Spray Paint		AS 9-89 DAS FEB 14 2018
190	QC	10 pcs	1/12/18	1/12/18	0.00	0.00	QC14		38 DAS
200	Packaging	10 pcs	1/12/18	1/12/18	0.00	0.00	Packaging3-1		CC 076 FEB 16 2018
210	QC21-SA	10 Ea	1/12/18	1/12/18	0.00	0.00	QC21		9-89 DAS JAN 11 2018

Part Op 120 - 1- ASSEMBLE AND WELD AS PER DWG 0 ***IMPORTANT DIMENSION IS 11.60" ***

Descriptions: 150 - Issue P/O: 38767 C of C is required

170 - INSPECT USING GO/NO GO GAUGE

180 - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG PRIMER BATCH: 138791

210 - PLEASE NOTE ON PO: Apply only Class 3 Cad to the threaded are only CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	647.7711	10	0	0	0
	647.7712	10	40	0	0
	647.7713	10	8	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date :	Step #:	QTY Effective :	MRB (QS1042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

DART
AEROSPACE
S026007

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Strut Assembly

PART NO: 647.7702
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/21/17
Job No: 169387

FAULT CATEGORY

☐ Power Loss/Surge	☐ Positioned Wrong
☐ Folio/Program	☐ Outside Dimensions
☐ Grain	☐ Over/Under tolerance
☐ Weld	☐ Part Incorrect
☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Out of Sequence	☐ Part Moved
☐ Off-set	☐ Drawing
☐ Misabeled	☐ Finish
☐ Fit/Function	☐ Misread
☐ Misaligned/off center	☐ Turning Sequence



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO038767**

E-MAILED
JAN 15 2018

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

PO No: PO038767

PO Date: 1/11/18

Due Date: 1/22/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	169386	647.7701	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
2	169387	647.7702	Strut Assembly Issue P/O : _____ Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II note: cad plate should not be too thick around tread	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$6.00/pcs	\$60.00
3	169877	647.2511	Nut Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed	1/22/18	10 pcs	0 pcs	10 pcs	\$2.3809523/pcs	\$23.81
4	169400	647.8511	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	11 pcs	0 pcs	11 pcs	\$2.3809523/pcs	\$26.19
5	169401	647.8512	Insert -Issue P/O to Groupe Altech: P/O -Passivate, MIL-S-5002 TYPE 6 AS PER DWG - Certificate of Conformity is required	Firmed	1/22/18	21 pcs	0 pcs	21 pcs	\$2.3809523/pcs	\$50.00

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PURCHASE ORDER

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	169271	RB T101338- 3	Jack Screw -Issue P/O to Groupe Altech: P/O -Zinc plate, ASTM B633 TYPE 1 SC2 -Certificate of Conformity is required	Firmed	1/22/18	3 pcs	0 pcs	3 pcs	\$30.00/pcs	\$90.00
Grand Total:										\$310.00
Order Notes										
Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A017 raw material identification (as applicable) A022 Apical Processing A024 process certifications A026 certification of material conformance A041 quality management system A042 dart notification by supplier A043 retention of quality documents A048 counterfeit parts avoidance, detection, mitigation and disposition program A049 supplier awareness Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.										

Plex 1/15/18 11:04 AM dart.lavoie.chantal



Certificat de Conformité / Certificate of Compliance

(005811-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

005811- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax:.

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courtier / Acc. No.	Bon de commande Client Customer Purchase Order No.
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22-Jan-2018

Curtis Anderson

PO038767

#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities				À venir/ Back Order
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	
1	647.7701 Rev.	647.7701 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADIUM CH	10	10	0	0	0
2	647-7702 Rev.	647-7702 CAD PLATE IAW QQ-P-416F CLASS 1 TYPE 2 CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD	CADIUM CH	10	10	0	0	0
3	647-2511 Rev.	647-2511 PASIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	10	10	0	0	0
4	647.8511 Rev.	647.8511 PASSIVATE MIL-S-5002 TYPE 6	PASSIVATION CH	11	11	0	0	0
5	647.8512 Rev.	647.8512 PASSIVATE MIL-S-5002 TYPE 6	PASSIVATION CH	21	21	0	0	0
6	RBT101338-3 Rev.	RBT101338-3 ZINC PLATE ,ASTM B633 TYPE 1 SC2	ZINC CH	3	3	0	0	0

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Notes Additionnelles / Additional Notes

CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD

Epaisseur réelle
Actual Thickness
Inspecteur Qualité
Quality Inspector
Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements
 Our financial and legal responsibility will not be higher than the amount of invoice.